

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016903**Date Inspected:** 18-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD

Segment # 10BW ~ 10CW

Repair Welding

This QA inspector observed, ZPMC qualified welding personnel identified as 040656 perform Shielded Metal Arc Welding (SMAW), weld joint identified as SEG061A-011; The Welding Repair Report (WRR) was B-WR15117. ZPMC CWI is identified as Mr. Zhu Zhong Hai. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-4G (4F) FCM-Repair. See the attached Photo.

Segment # 10BE ~ 10CE

This QA inspector observed, ZPMC qualified welding personnel identified as 053821 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE10C-001; ZPMC CWI is identified as Mr.An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1. See the attached Photo.

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Segment # 10BE ~ 10CE

This QA inspector observed, ZPMC qualified welding personnel identified as 044515 perform Shielded Metal Arc Welding (SMAW), weld joint identified as OBE10C-002; ZPMC CWI is identified as Mr. An Qing Xiang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-TC-U4b-FCM-1.

Segment # 10BE~10CE

This QA inspector observed, ZPMC qualified welding personnel identified as 040458 perform Flux Core Arc Welding (FCAW), weld joint identified as BP130-001-021; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

Segment # 10BE

This QA inspector observed, ZPMC qualified welding personnel identified as 044473 perform Flux Core Arc Welding (FCAW), weld joint identified as BP184-001-049; ZPMC QC is identified as Mr. Wang Zhu. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132.

Segment # 10AE

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that American Bridge Fluor (ABF) Quality Assurance (QA) personnel had performed Magnetic Particle Testing (MT) on Bottom to Side Plate Hold Back Weld in OBG segment 10AE at panel point 86.

Segment # 10AW

During random visual inspection this Caltrans Quality Assurance (QA) inspector observed that ZPMC personnel had performed heat straightening on various locations on longitudinal Diaphragm in OBG segment 10AW at panel point 87. ZPMC QC is identified as Mr. Shi Lei the variables recorded by QC appeared to comply with the Heat Straightening Report (HSR) was HSR1 (B) 9053.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
